

# Work Order ID 85518

**\*85518\***

Page 1

June-08-12 2:48:28 PM

Item ID: D3030-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Lock

Stop **\*NS2\***

Start Date: 08/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/08 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3030

Rev A

100

PURCHASING

0.00

**\*100\***

Purchasing

Memo

0.00

Purchasing

Issue P/O: 17181 a)Possible supplier: Northern Aero Industriesb)Order P/N B83603-1c)Material: 2024-T351 (QQ-A-225/6)d)0.010" max diff. Between 0.525" dim each sidee)All diameters concentric within 0.005 T.I.R.f)All dimensions are in inchesg)Tol

CL 12/06/11 (6)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

CL 12/7/10 (6)

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
16  
17/6/11

(6)

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June-08-12 2:48:28 PM

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**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: 624

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

6 12/9/11

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MLJ 12/09/12

MF  
12-09-12

# Picklist Print

June-08-12 2:48:33 PM

Page 1

Work Order ID: 85518

**\*85518\***

Parent Item: D3030-1

**\*D3030-1\***

Parent Item Name: Lock

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 01.06.08 Removed chemical conversion EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B83603-1		Purchased	No			110	Each	0.0000	1	6			
<b>*B83603-1*</b>									<b>**</b>				
Lock													

*P12/5/10*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

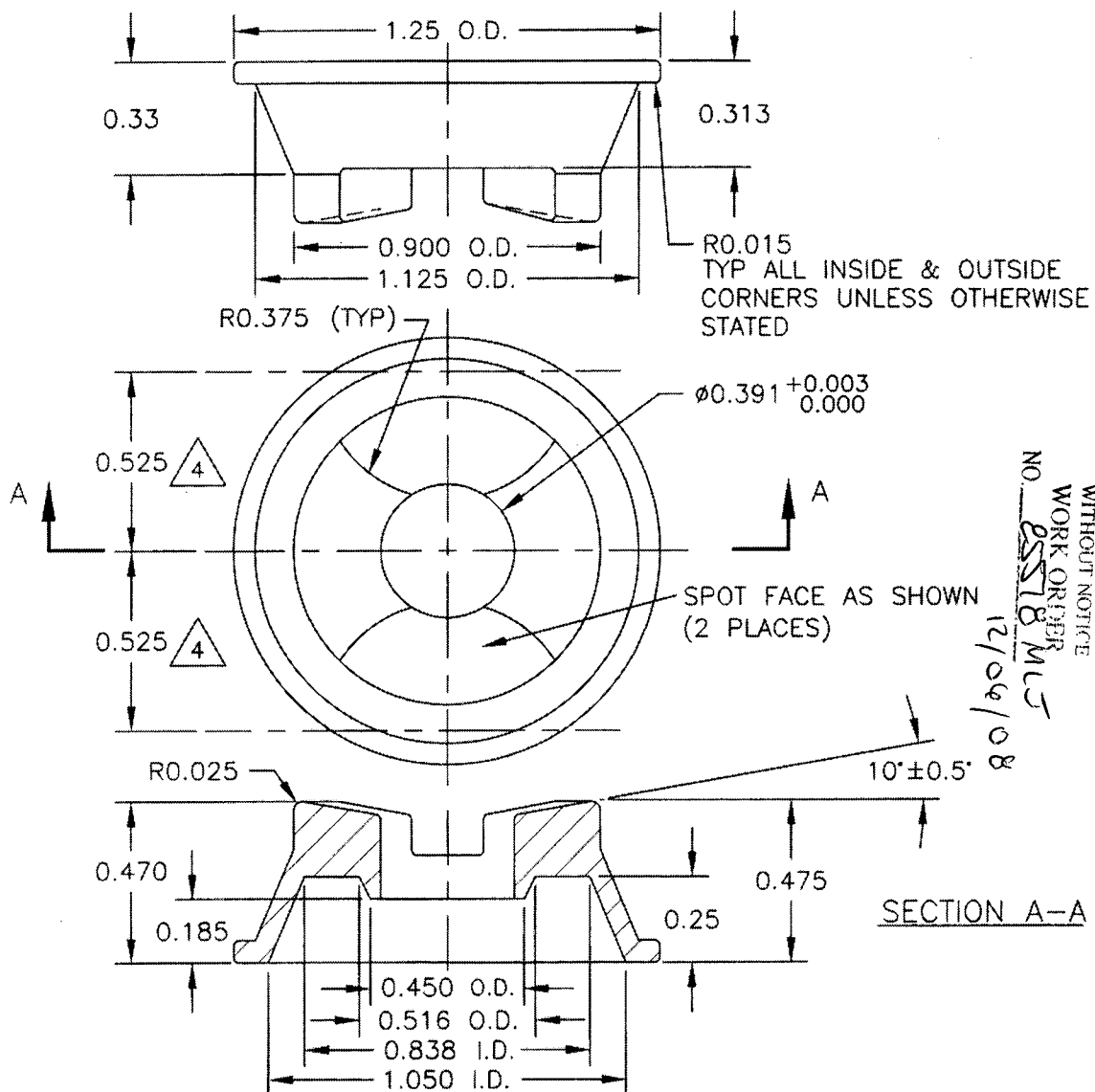
**FAULT CATEGORY**

Landing Gear	Hardware	General	Other
<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Off-Set
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Orientation Misread
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Inspection Unqualified	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ripples on Inner Bend	<b>Drill Holes</b>	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Part Lost
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Raw Material
	<input type="checkbox"/> Too Many		<input type="checkbox"/> Set-up
			<input type="checkbox"/> Supplier
			<input type="checkbox"/> Temperature/Cure
			<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3030	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE LOCK	SCALE 2:1
A	01.05.18	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING



D3030-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83603-1
- 2) MATERIAL: 2024-T351 (QQ-A-225/6)
- 3) ALL DIAMETERS CONCENTRIC WITHIN 0.005 T.I.R.
- 4) 0.010 MAX DIFF. BETWEEN 0.525 DIM EACH SIDE.
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
01.05.30

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SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 85518 MJS  
12/04/08



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO17181

Purchase Order Date 6/11/12

PO Print Date 9/05/12

Page Number 1 of 1

Order From :

VU-NOR003

NORTHERN AERO INDUSTRIES LTD.  
25 DUNLOP AVENUE  
WINNIPEG, MB R2X 2V2  
CA

Contact Name

Vendor Phone

204-772-9922

Vendor Fax

204772-7568

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

REVISED \$ -

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	Vendor Part Number						
	3603-1	LOCK	9/14/12 Yes	6.00 Each	FedEx PI collect	\$12.0000	\$72.00

Special Inst: AS PER DWG D3029 REV. A  
B85519  
MATERIAL: Ø0.041" PIANO WIRE  
DIMENSIONS: MEAN DIA. = 0.625"  
PITCH = 0.20" LENGTH = 1.20"  
ALL DIMENSION ARE IN INCHES

2	B83603-1	Lock	9/14/12 Yes	6.00 Each	FedEx PI collect	\$85.0000	\$510.00
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Special Inst: AS PER DWG D3030 REV. A  
B85518  
MATERIAL: 2024-T3 AS PER QQ-A-225/6  
0.010" MAX DIFF. BETWEEN 0.525" DIM.  
EACH SIDE  
ALL DIAMETERS CONCENTRIC WITHIN  
0.005 T.I.R  
ALL DIMENSION ARE IN INCHES

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

PO Total: \$582.00

Change Nbr: 3

Change Date: 9/05/12

No substitution or deviation without  
consent.

Certificate of Conformity or Material  
Certification required - YES NO

**CERTIFICATE OF CONFORMITY**

Form Tracking No. 27436-1

Work Order/Contract/Invoice: PO 17181

Cage Code: MFR L0555

Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Spring	B83605-1	6	12-3551	New
2	Lock	B83603-1	6	12-3345	New

DAA  
16  
S. G.

716914

Remarks:

THESE ITEMS CONFORM TO DESIGN DATA B83604 (REV. N/C).

**New-Unused Parts/Material Certification**

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature

Name R.D. WILLIAMSON

Date (dd mmm yyyy)  
07-Sep-12

**Used, Repaired or Overhauled Parts Certification**

The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.

Signature

Name

Date (dd mmm yyyy)

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.

**ACS-NAI Ltd.**

25 Dunlop Avenue  
R2X 2V2 Winnipeg  
Canada  
Tel : 204-772-9922  
Fax : 204-772-7568

Delivery No. : 3080  
Delivery Date : 09/06/2012  
SO No. : 27436  
Your Reference : PO: 17181  
Delivery Method : FEDEX  
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

Item	Description Batch Number	Total		Qty	
		Ordered	Unit	Delivered	Delivery Date
B83605-1	SPRING 12-3551	6	EA	6	09/14/2012
B83603-1	LOCK 12-3345	6	EA	6	09/14/2012

Ship via FedEx P1 to Account # 151793240  
Email: clavoie@dartaero.com

Ph: 613-632-9577

Packages: 0

Gross Weight: 0.00

Net Weight:

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts  
1270 Aberdeen Street

Hawkesbury K6A 1K7  
Canada

0.00

**Remarks****Certification Statement**

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date: